

Work Order ID 102967

June-12-13 9:23:27 AM

102967

Page 1

Item ID: D3033-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Seat Track

Stop

NS2

Start Date: 6/11/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *MP*

Date: 13-6-13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3033	Rev A1								
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100 0.00

100 BAND SAW

Bandsaw

Jespa Bandsaw

Memo 0.00

1-Cut D3033-144 extrusion to length per D3033-I detail of dwg D3033 Ensure
cut is started at correct place per drwgBatch. *96199* 2-Deburr

AC 13 07 03 X7

13-7-9 DAS 6 7 QH

110 0.00

110 QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo 0.00

27 6 27 6 13-7-10

120 0.00

120 HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1 0.00

Memo 0.00

6 13-7-10

DQA:

SAHDate: 13/07/18

QA Closed:

XDate: 13-7-12

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order:	102967	DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No.	D3033-1	Rework	Skid-tube	Crosstube	Water Jet	Engineering					
NCR No.	13-2842	Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality					
		Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other					
		Suspected Unapproved	Large Fab	Composite	Supplier						

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	13-07-03	100	x7	instead of parts being cut on center between circles they were cut center of circles	DAS 16 9-89	Scrap + replace B 96799	13	13	DAS 16 8-89
Equip/Tooling									
Handling/Pre									
Material									
Operator	X			RC. misread diag/ no rework station	072047 13/07/13	\$50.93	13		072042 13/07/03
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions	Pressure/Forced Set-up
Bending	Bend	Grain	Over/Under tolerance	Temperature/Cure
Centre Not Concentric	BOM/Route	Hardware	Part Incorrect	Weld
Cracks	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Part Lost/Missing	Wrong Stock Pulled
Crimp/Kink/Ripple/Wave	Burrs	Instructions Incomplete/Unclear	Part Moved	
Cuffs	Contamination	Misaligned/off center	Positioned Wrong	
Crushing	Countersink	Mislabeled	Power Loss/Surge	
Heat Treat	Cut Too Short	X Misread		
Inspection Strip in Tube	Drawing	Off-set		
Marks/Chatter	Drill Holes	Out of Calibration		
Turning Sequence	Finish	Out of Sequence		
Wave/Twist in Tube	Fit/Function			

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Page 2

Item ID: D3033-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Seat Track

Stop

NS2

Start Date: 6/11/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

QC

Quality Control

QC3-Inspect Part Finish

0.00

6x6

MM 13.07.11

140

140

Packaging

Packaging

Identify as per dwg & Stock Location

ST177

0.00

Memo

0.00

6x

SP

B710

150

150

QC

Quality Control

QC21-Final Inspection - Work Order Release

0.00

Memo

0.00

13/7/11 J

AB07V

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Water Jet <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other					

Picklist Print

Page 1

June-12-13 9:23:27 AM

Work Order ID: 102967

Parent Item: D3033-1

Parent Item Name: Seat Track

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A07.01.03New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3033-144 Seat Track		Manufactured	No:			100	f	30.9690	1.51	9.5368422		21 113-07-03	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST209a			30.969				x 12		

96799

DQA: _____ Date: _____

Date:



WORK ORDER NON-COMPLIANCE / UPDATE

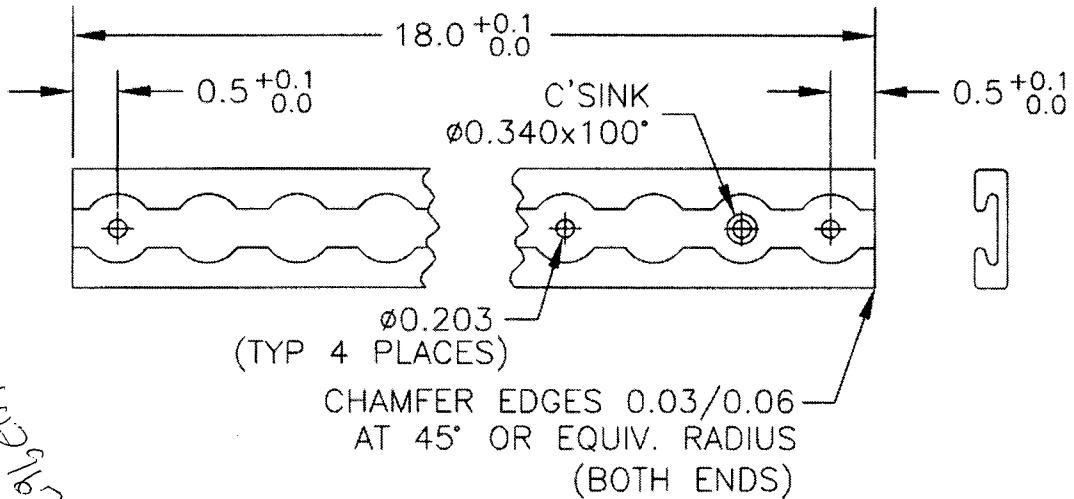
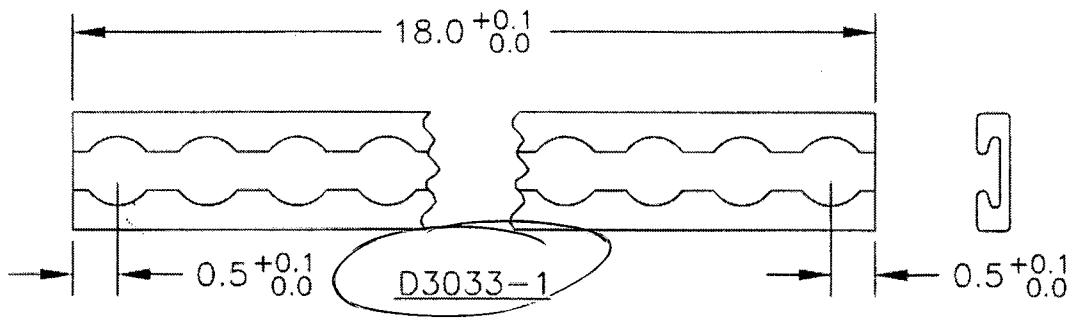
QA Closed: _____ Date: _____

Work Order update only



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3033	SHEET 1 OF 1
DATE		TITLE	SCALE
01.05.18		SEAT TRACK	1:2
A	01.05.18	NEW ISSUE	
AI	03.08.25	NOTE 1 MODIFIED	

SPECIFICATION CONTROL DRAWING



(CAN MAKE FROM D3033-1)

D3033-1 & D3033-3

- 1) MAKE FROM: ANCRA, P/N 40456-11-144
OR BROWNLINE, P/N 20276-144-0-0] **D3033-144** **AI**
- 2) DESCRIPTION: MEDIUM DUTY SEAT TRACK
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.05.30

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>
Cuffs	Contamination	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>
Crushing	Countersink	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>
Heat Treat	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>
Inspection Strip in Tube	Drawing	<input type="checkbox"/>	Other	<input type="checkbox"/>
Marks/Chatter	Drill Holes	<input type="checkbox"/>		
Turning Sequence	Finish	<input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>		